

Please add the following new claim.

A3
21. The process as in claim 10, wherein the process includes heat treating at a temperature in the range of about 1550°F \pm 25°F and holding for about one hour, followed by a heat treatment in the range of about 1325°F \pm 25°F for about eight hours, followed by a heat treatment in a temperature in the range of about 1200°F \pm 25°F for about one hour, so as to develop γ' and γ'' , while also relieving welding stresses in the welded article after the step of welding the wrought article to the cast article

IN THE SPECIFICATION

Please amend the specification as follows:

A4
[0021] After the cast Inconel 718 component has been solutioned within the temperature range of about 1950°F to about 2150°F and the initial wrought portion has been machined away, a new wrought portion can then be attached to the casting. When the article includes a cast Inconel 718 component welded to either a wrought Waspaloy component or a wrought Rene-41 component, after the components are welded together, in order to relieve weld stresses and to properly age the article, the article should be heat treated in the range of about 1500°F to about 1600°F for a first preselected period, about one hour, followed by a heat treatment in the range of about 1250°F to about 1350°F for a second preselected period, about eight hours, followed by a heat treatment in the range of about 1150°F to about 1250°F for a third preselected period, about one hour. In a more preferred embodiment, in order to relieve welding stress and to age the article, the article should be heat treated at about 1550°F \pm 25°F for about one hour, followed by a heat treatment at about 1325°F \pm 25°F for about eight hours, followed by a heat treatment at about 1200°F \pm 25°F for about one hour.

AS
[0022] After the cast Inconel 718 component has been solutioned within the temperature range of about 1950°F to about 2150°F and the initial wrought portion has been machined away, a new wrought component can then be attached to the casting. When the article is a cast Inconel 718 component welded to a Inconel 907 wrought component, after the components are welded together, in order to relieve weld stresses and to age the article, the article should be heat treated